

Date: Wednesday, 1/18/2006 4:04:14 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MOUNTING LUG  
 Job Number : 25554  
 Estimate Number : 10255  
 P.O. Number : N/A Part Number : D22301  
 This Issue : 1/18/2006 S.O. No. : N/A Drawing Number : D2230 REV F  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : F  
 Previous Run : 25553 Material : N/A  
 Due Date : 2/15/2006 Qty: 200 Um: Each  
 Written By : SEE COMMENT BELOW  
 Checked & Approved By :  
 Comment : Est D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total: 14.3430 f(s)  
 Lug Extrusion D2423 Extrusion  
 Batch: B23779

2.0 BAND SAW BAND SAW



Comment: BAND SAW  
 Cut D2423 extrusion to 0.82"  
 Batch: B23779

BG 06.01.25

201

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1

PG



Comment: HAAS CNC VERTICAL MACHINING #1  
 1-Machine per folio D2230-1  
 (Check for crack while loading into the machine.)  
 2-Tumble and deburr rough edges after tumbling

note P.O. # 0000446

06/01/26

Issue P.O

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

RG



Review & Inspect



Comment: ~~INSPECT PARTS AS THEY COME OFF MACHINE~~

1/18/10 (203)

5.0 QC5 SECOND CHECK



Comment: SECOND CHECK

Inspect Level 5

06.01.17 203

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/03/01  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/18/2006 4:04:15 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 25554

Part Number: D22301

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FF 06-20-02/540

06.02.20

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

DC 06/02/25

(203)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/12/27

(203)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

ST 370

06/12/27

(146) (203)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/01

Job Completion



U 0603-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries -

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	25554
<b>Description:</b> Mounting Lug	<b>Part Number:</b>	D2230-1
<b>Inspection Dwg:</b> D2230 <b>Rev:</b> F		<b>Page 1 of 1</b>

## FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**      ☐ **Prototype**

[illegible]

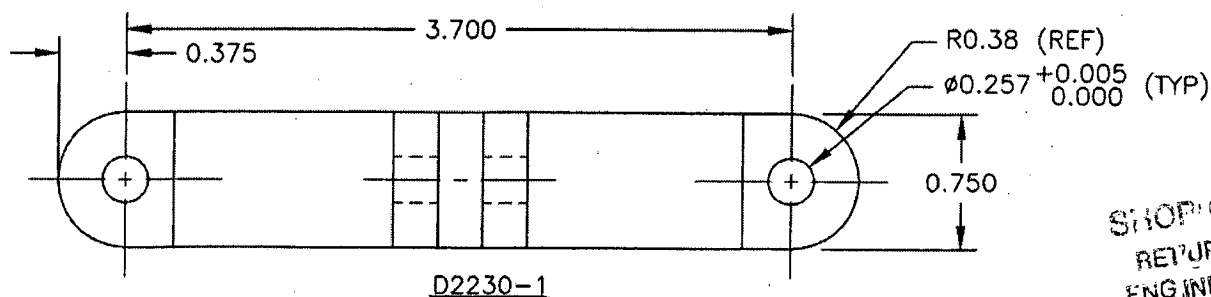
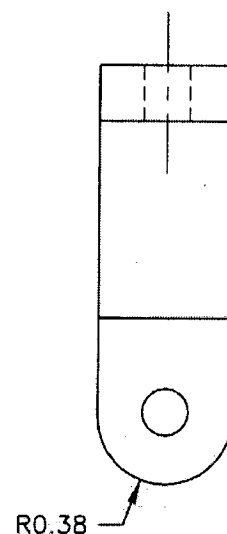
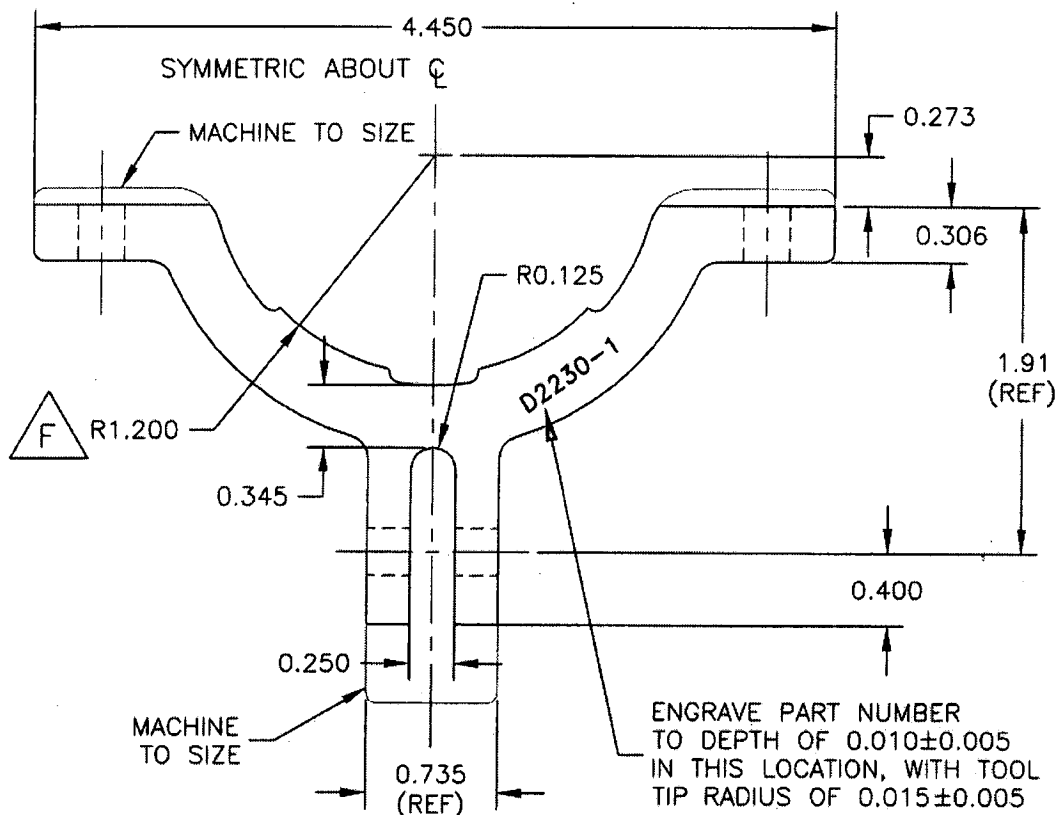
<b>Measured by:</b>		<b>Audited by:</b>		<b>Prototype Approval:</b>	N/A
<b>Date:</b>		<b>Date:</b>		<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue	KJ/RE	



**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2230	REV. F SHEET 1 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1
C	94.03.30	RE-DESIGN	
D	95.01.04	RE-DESIGN	
E	95.01.04	RE-DESIGN	
F	99.12.13	REDESIGN; R1.200 WAS R1.100	

**RELEASED**  
99.12.21 DS

MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

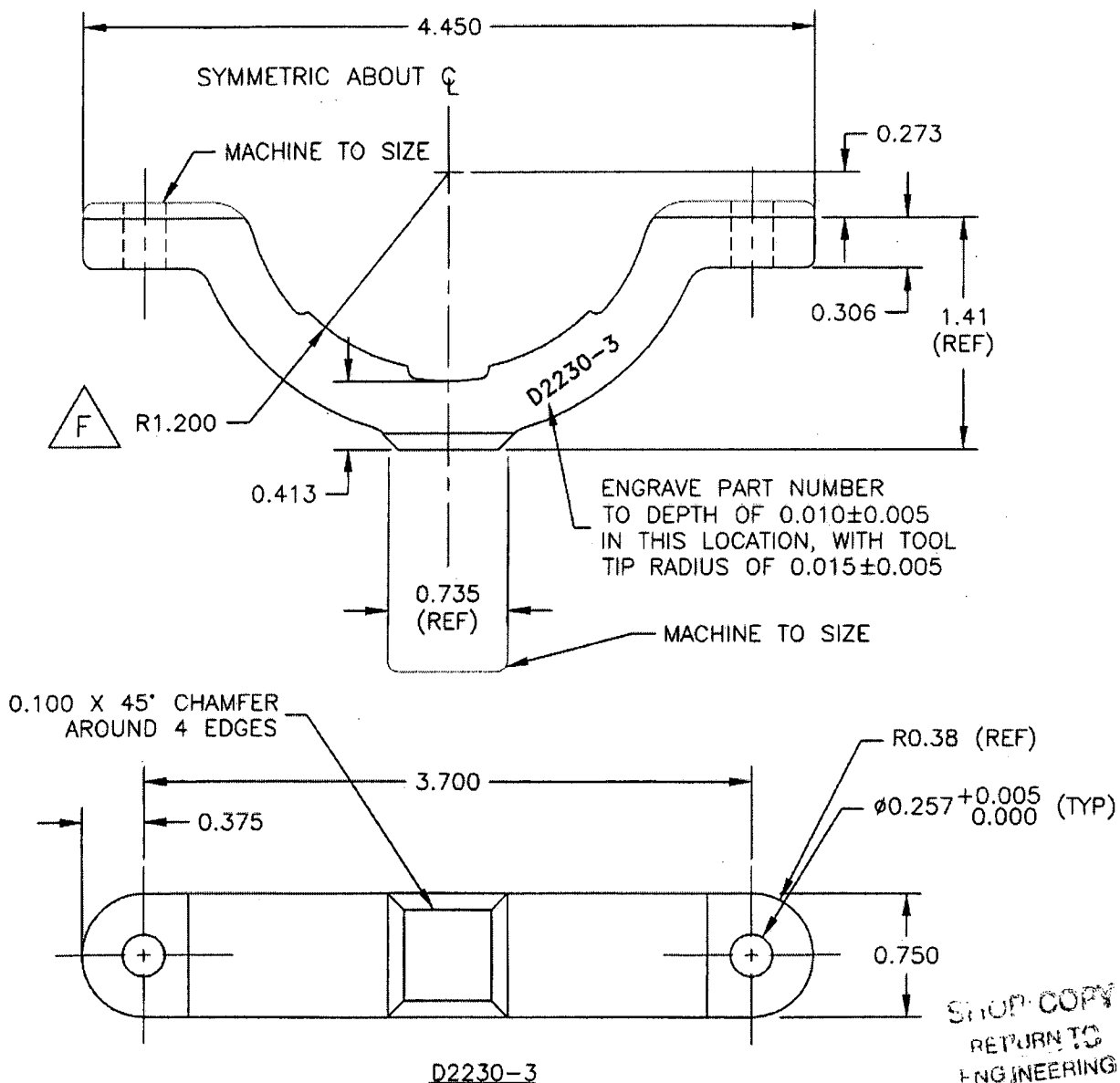
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
PROJECT TO A...

25554



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

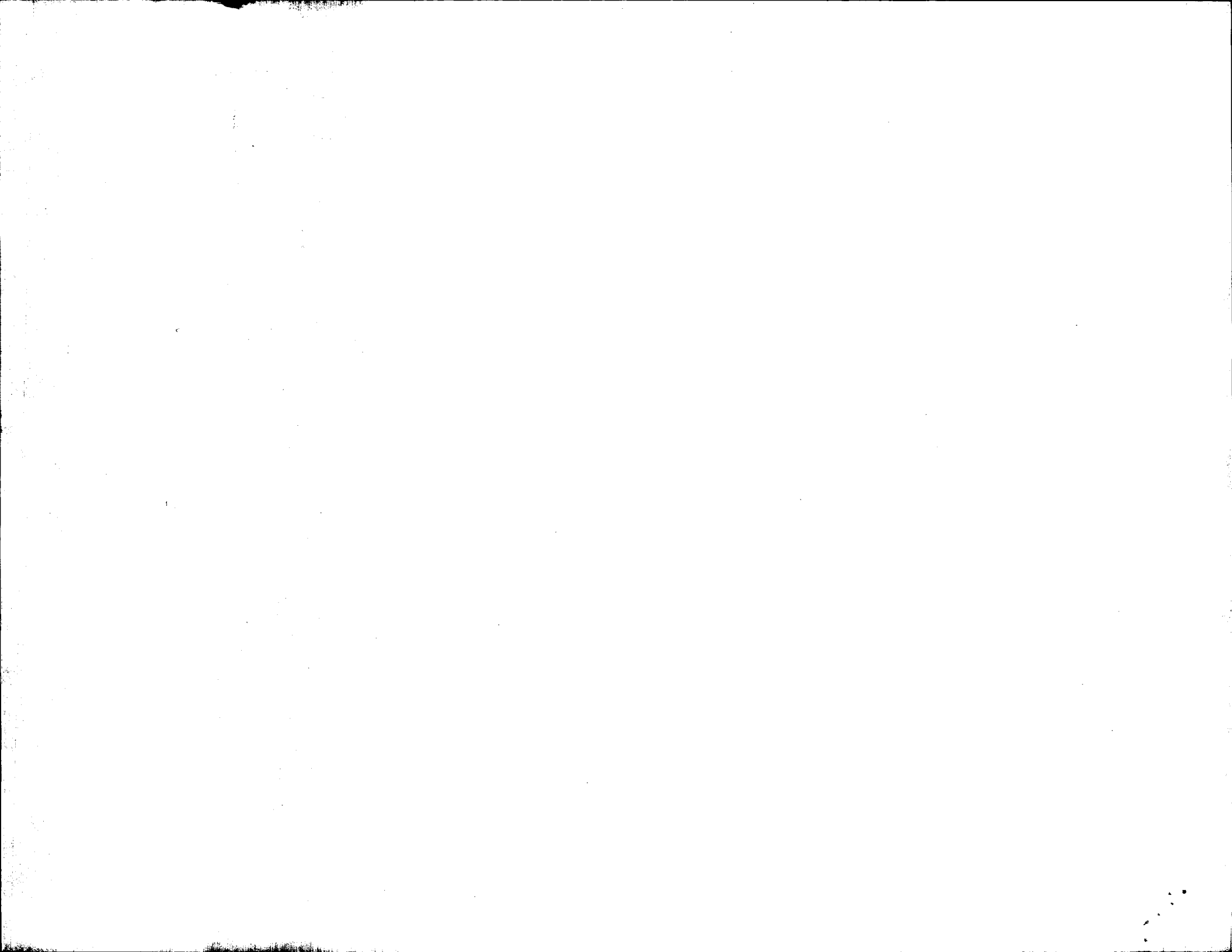
RELEASED  
79.12.21 DS



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 25554







## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

QUANTITY

200

PART NUMBER

D2230-1

PART NAME

Mounting Lug

P.O. NUMBER

446

MATERIAL supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

*Shig (Regula) Walz*  
Shig (Regula) Walz

Vankleek Hill, February 3, 2006

*6612-17*





P.O. Box 781  
Tel. (613) 678-3957 & 678-2782

20 Terry Fox Drive  
Fax (613) 678-3956

Vankleek Hill, Ontario, K0B 1R0  
metec@metec.ca / www.metec.ca

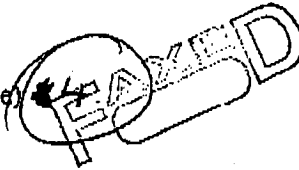
Fax cover page

Vankleek Hill, February 15, 2006

to Linda Lacelle  
Dart

from Shigi Walz

Pages (incl. coverpage)



Hi Linda,

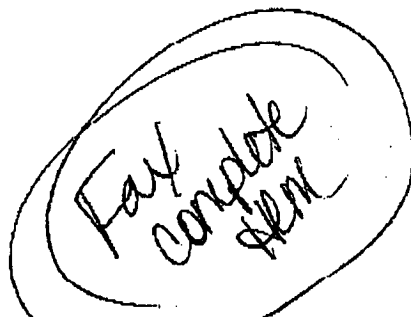
Please find attached the delivery slip for the lugs Marcus delivered this morning. Included <sup>are</sup> also the Certificates of Conformity for this delivery as well as for the delivery from February 3, 2006.

Thanks a lot!

*Shigi Walz*  
Shigi Walz

*2nd attempt*

*Only received (3 pages, coverpage: 2 Cents)  
- 2 Certificates of Conformity*



*Shelly*

P.O. Box 781  
Tel. (613) 678-3957 & 678-2782

20 Terry Fox Drive  
Fax (613) 678-3956

Vankleek Hill, Ontario, K0B 1R0  
metec@metec.ca / www.metec.ca

**CERTIFICATE OF CONFORMITY****SOLD TO:**

Dart Aerospace Ltd  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

**SHIPPED TO:**

same

QUANTITYPART NUMBERPART NAMEP.O. NUMBER

203

D2230-1

Mounting Lug

446

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi (Regula) Walz

Vankleek Hill, February 15, 2006

A large, stylized handwritten signature is written over the date. Below the signature, the date "06.02.17" is handwritten.

